

- | | | | |
|----------------|-------------------------------------|---------|-------------------------------------|
| 12, 22, 32, 42 | DRIVING CIRCUIT | 33 | FINISHING TOOL FEED CONTROL CIRCUIT |
| 52 | CENTRAL PROCESSING UNIT | 43 | WORKING PIECE FEED CONTROL CIRCUIT |
| 13 | MAIN SHAFT ROTATION CONTROL CIRCUIT | 53 | COUNT SECTION |
| 15 | SPEED SIGNAL GENERATION CIRCUIT | 56 | ROM |
| 23 | ROUGHING TOOL FEED CONTROL CIRCUIT | 57, 57a | POSITION DATA TABLE MEMORY |
| | | 61 | PROCESSING DATA INPUT SECTION |

FIG. 2A

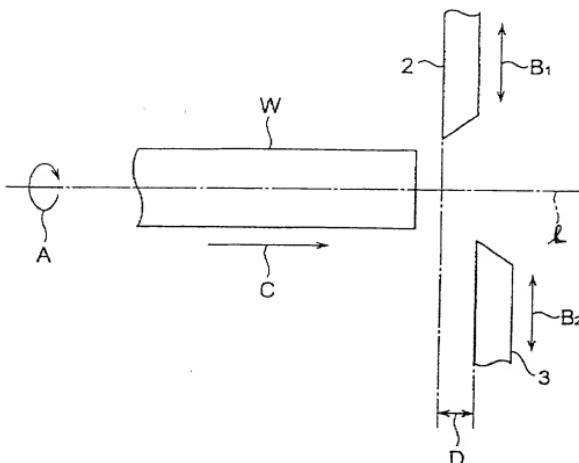


FIG. 2B

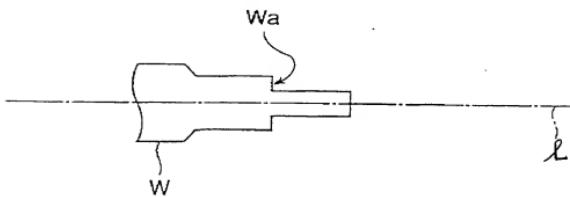


FIG. 3

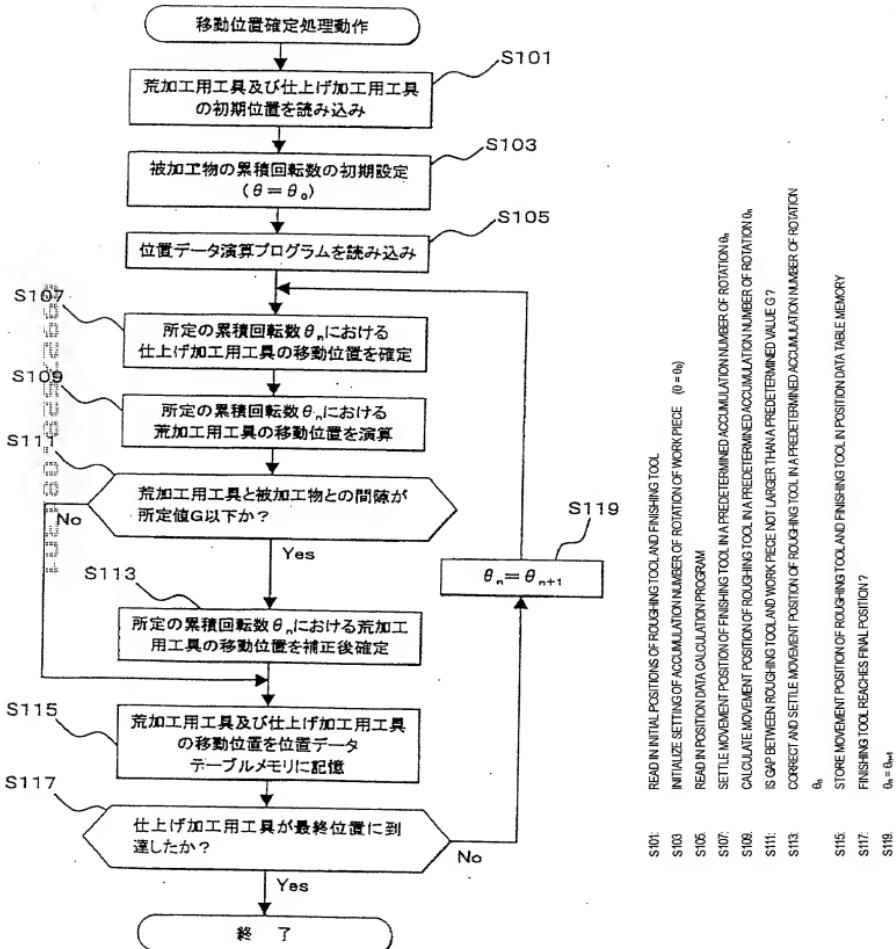
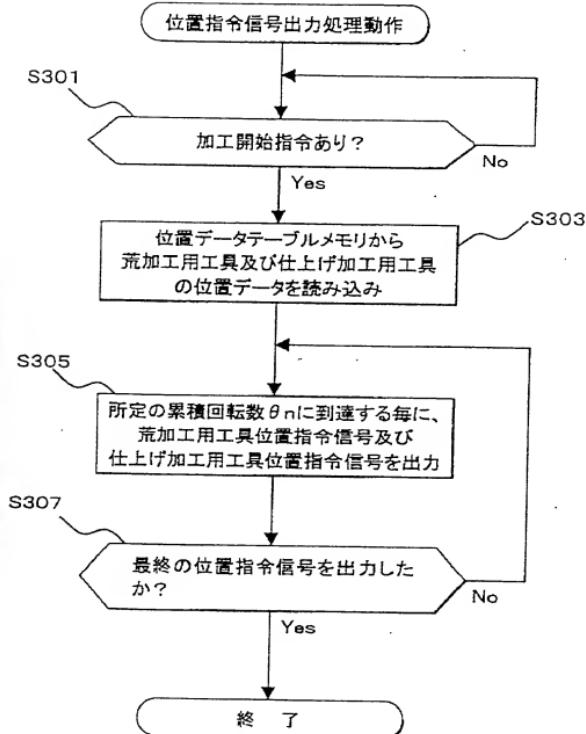


FIG. 4

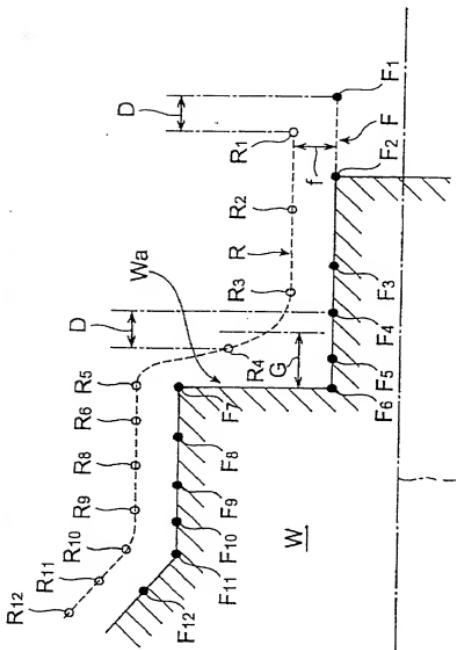


S301: IS THERE PROCESSING START COMMAND ?

S303: READ IN POSITION DATA OF ROUGHING TOOL, FINISHING TOOL FROM POSITION DATA TABLE MEMORY

S305: OUTPUT ROUGHING TOOL POSITION COMMAND SIGNAL AND FINISHING TOOL POSITION COMMAND SIGNAL, EVERY TIME WHEN THE NUMBER OF ROTATION REACHES A PREDETERMINED ACCUMULATION NUMBER OF ROTATION n.

S307: IS FINAL POSITION COMMAND SIGNAL OUTPUTTED ?



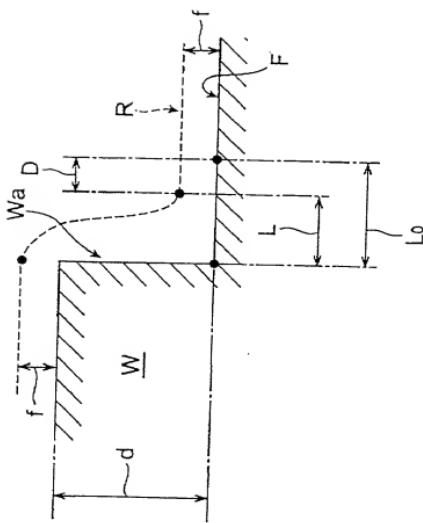


FIG. 7A

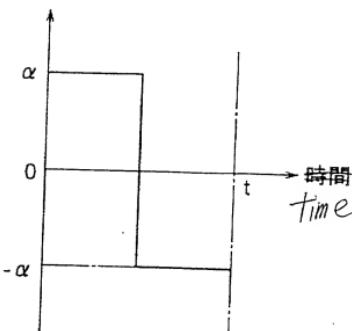
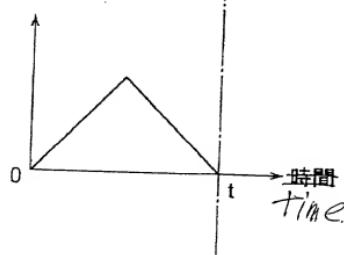


FIG. 7B



Movement speed of
 v_{so} /
varying t_0 /
荒加工用工具の
移動速度